

UNDER REVIEW

URF 19-1118 19.10.30 (VM)

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	QTY.	ØA +.000 -.002	PIN TYPE	MATERIAL
KTSO12T236-710	2	.372	III	1018 RND. BAR Ø1/2 x 5/8

RED BARN MACHINE			
TITLE KTSO12T236 SERIES DP TRI-ROLLER SWAGING TOOLS; LOCATING PIN			
DWG NO. TOOL# (see chart)-15			REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT	
XXX ± .005		FINISH	
XX ± .01		SPEC	
X ± .1		BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING	
SCALE NTS		DATE 8-14-08	
		SHEET 9 of 9	




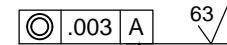
URF 19-1118 19.10.30 (VM)

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NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE	
TITLE KSTD012T236 SERIES DP TRI-ROLLER SWAGING TOOLS; PIN	
DWG NO. T.OOL# (see chart)-9	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED _____ HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS DATE 8-14-08 SHEET 6 of 9



GUIDE

URF 19-1118 19.10.30 (VM)


1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE			
TITLE KSTSD12T236 SERIES DP TRI-ROLLER SWAGING TOOLS; GUIDE			
DWG NO. TOOL# (see chart)-7			REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 8-8-08	SHEET 5 of 9	

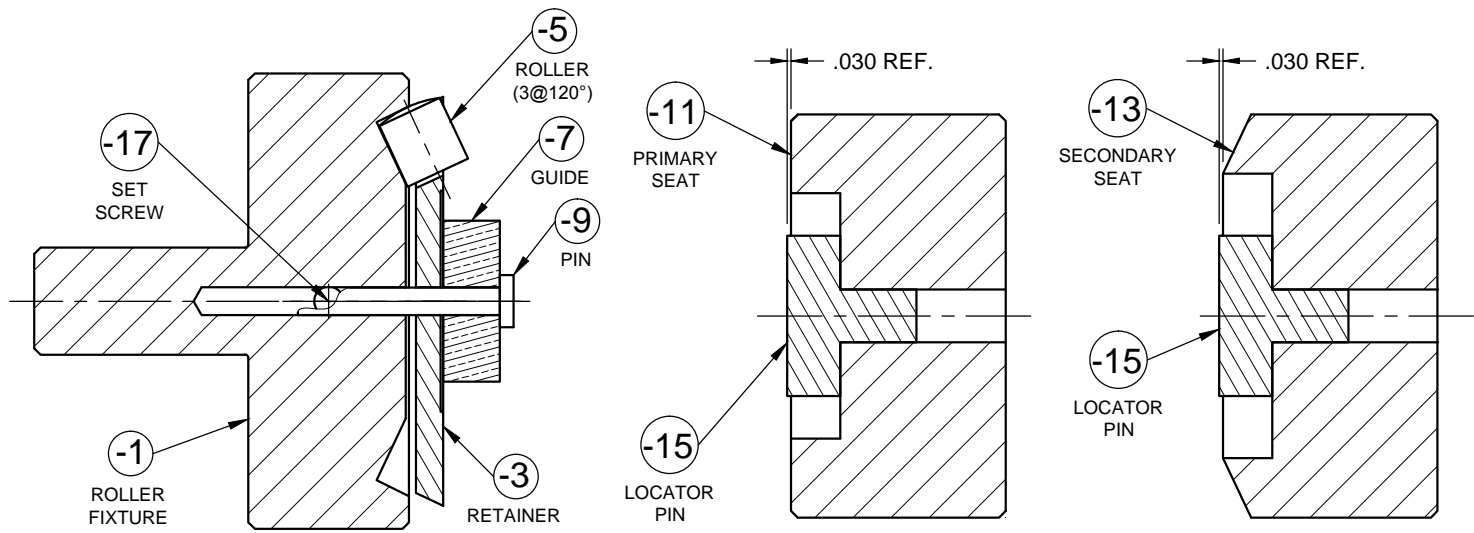


URF 19-1118 19.10.30 (VM)

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 RED BARN MACHINE			
TITLE KSTSD12T236 SERIES DP TRI-ROLLER SWAGING TOOLS; ROLLER (x3)			
DWG NO. TOOL# (see chart)-5			REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 8-8-08	SHEET 4	of 9

REVISIONS				
REV	DESCRIPTION			DATE
-	-	-	-	-



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.
4. ENGRAVE AS SHOWN WITH "KST" & BEARING No.

UNDER REVIEW

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BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
SO12T236-710	KSTSO12T236-710

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	SEE CHART	SECONDARY SEAT	SEE CHART	8
		-15	SEE CHART	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE			
TITLE		KSTSO12T236 SERIES DP TRI-ROLLER SWAGING TOOLS	
DWG NO.	TOOL# (see chart above); ASSEMBLY		REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT LISTED PER ITEM	
.XXX ± .005		FINISH LISTED PER ITEM	
.XX ± .01		USED ON BEARING	
.X ± .1		SEE ABOVE	
UNLESS OTHERWISE SPECIFIED		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
1. BREAK ALL SHARP EDGES		SCALE NTS	
.015 x 45° PR .015 R		DATE 8-14-08	
SHEET 1 of 9			


NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNDER REVIEW

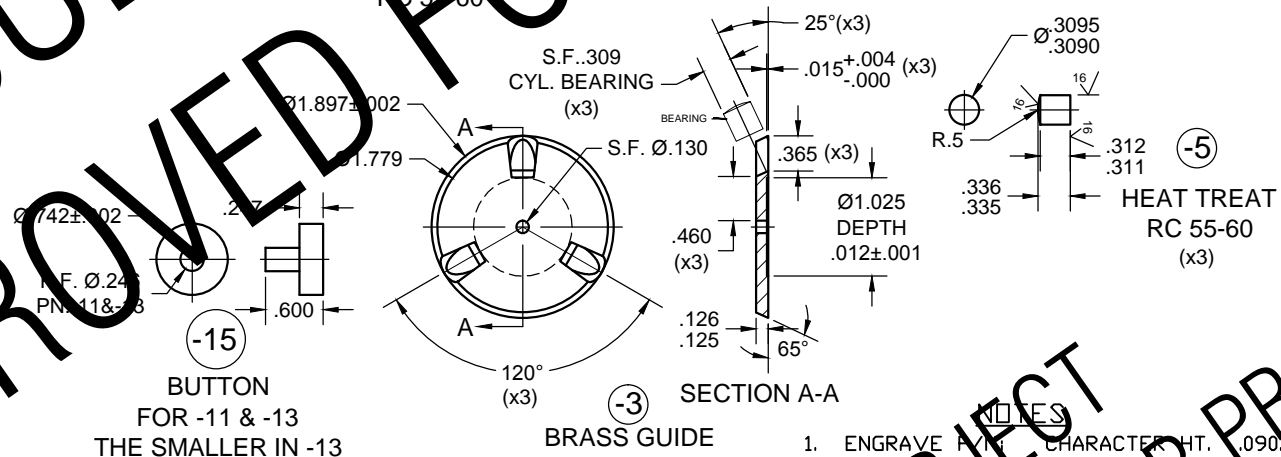
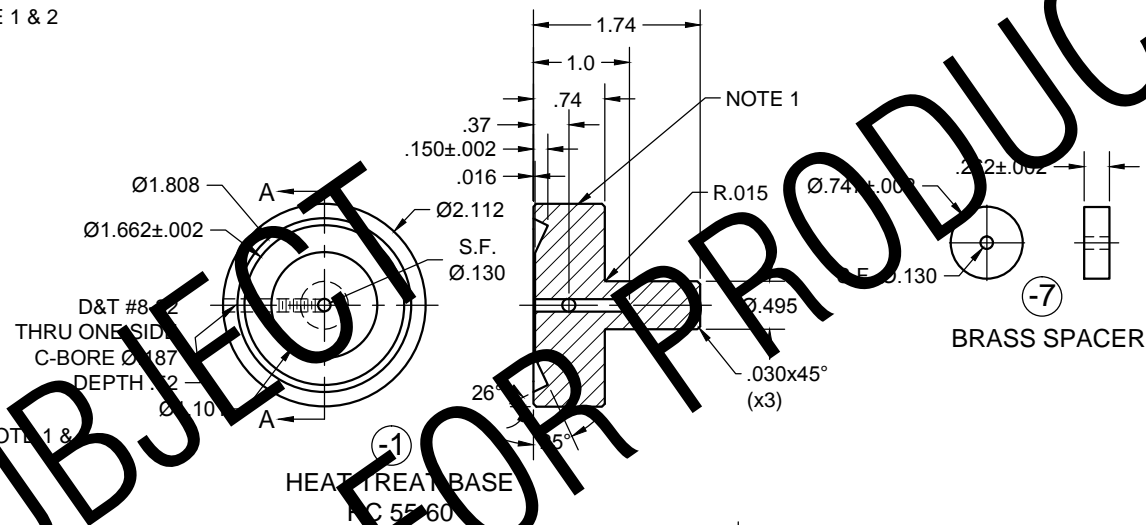
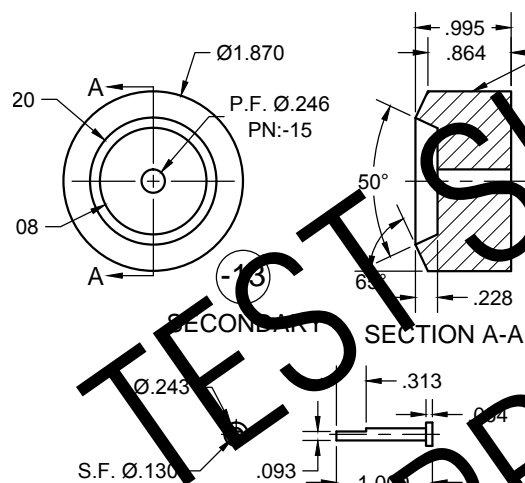
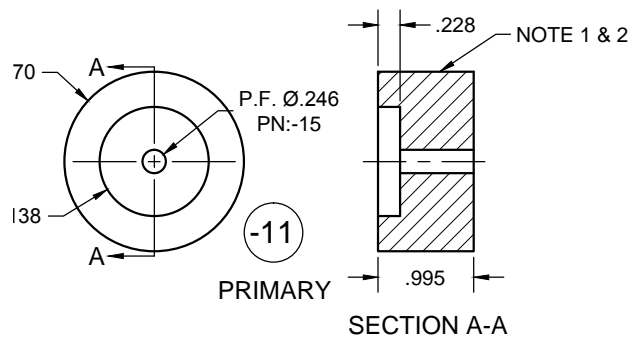
URF 19-1118 19.10.30 (VM)

	PART #	QTY	DESCRIPTION
	-1	1	--

DRAWN BY: PERRITT	 RED BARN MACHINE		
CHECKED			
HEAT TREAT FINISH SPEC			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°			
USED ON MODEL ?	TITLE	TITLE	
	DWG NO.	PART #	REV.
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		

URF 19-1118 19.10.30 (VM)

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



IT #	QTY	DESCRIPTION
1	1	0-1" DRILL ROD Ø2-1/8 x 1-7/8
3	1	BASS RND Ø2 x 5/16
5	3	0-1" DRILL ROD Ø3/8 x 1/2
7	1	BASS RND Ø3/4 x 3/8
9	1	1018 RND Ø1/4 x 1-1/8
11	1	1018 RND Ø1-7/8 x 1-1/8
13	1	1018 RND Ø1-7/8 x 1-1/8
5	1	1018 RND Ø3/4 x 3/4

	USED ON MODEL
	?

DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC	BLACK OXIDE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
.XXX $\pm .005$	FRACTIONS $\pm 1/32$
.XX $\pm .01$	ANGLES $\pm 5^\circ$
.X $\pm .1$	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x .45" PP .015 P	

 RED BARN MACHINE	
TEST SU TEST APPROVED FOR SPARKING TOOLS	
DWG NO.	RB ST1016
DATE 1-24-27	REV